Wednesday, 2/15/2006 1:25:13 PM

User:

Linda Lacelle

: CU-DAR001 Dart Helicopters Services

Customer Job Number : 25823

: 10826 **Estimate Number** :NA P.O. Number

: 2/15/2006 This Issue

Prsht Rev. : NC

First Issue : 24874 Previous Run

S.O. No. : NIA

05.11.02

: NIA

: MACHINED PARTS

Checked & Approved By

Comment

COMMENT

Removed 303 SS KJ/EC

Due Date

Drawing Name

Process Sheet

: SPACER BUSHING

Part Number : D23273 : D2327 REV C

Drawing Number Project Number

Drawing Revision Material ***

AIN: : 2/28/2006

: N/A

Qty:

Um:

Each

Additional Product

Job Number:

Written By



Seq. #:

1.0

Machine Or Operation:

Description:

303 Round Bar 0.375"

Comment: Qty.: 0.1641 f(s)/Unit

Total:

8.2058 f(s)

Inventory

M303R0375

Material: AISL303 Round Bar Ø0.375"

(M304R0.375)

Batch: M100255

HARDINGE CNC LATHE SMALL

2.0

HARDINGE

Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327

Deburr

NS

06/03/23

50 k

3.0

QC2



PARTS AS THEY COME OFF MACHINE

INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

50

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: WS3

C206/03/27



Dart Aerospace Ltd

W/O:			WORK ORDER O	HANGES				
DATE	STEP	PI	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	3	ţ						
Part No):	PAR #:	Fault Category:	NCR: Yes	NØ DQ	A:	Date: ⊵	6/63/28

QA: N/C Closed: ____ Date: ____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC	Corrective Action Section B			Verification	A1				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
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	3.	•									

NOTE: Date & initial all entries

Date: User:

Wednesday, 2/15/2006 1:25:13 PM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 25823

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21



Job Completion



D06/03/08 M 06.03.28

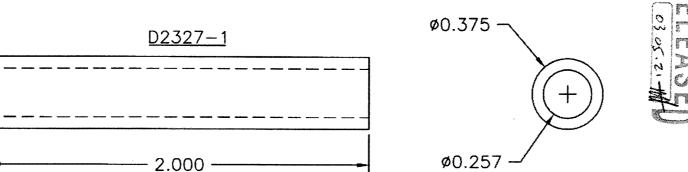
Dart Aerospace Ltd

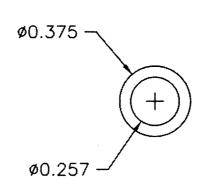
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DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	

					QA: N/O	C Closed:	Date: _			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Corrective Action Section B			Varification	A				
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		
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NOTE: Date & initial all entries

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	0	S DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR C	
	OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	Ž	
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D2327-3
1.750

NOTE:
1) MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC.

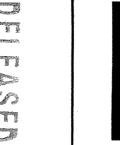
M304TR0.375W.065)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.010





 BW DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
 снескер,	APPROVED	DRAWING NO. REV. C
4	f	D2327 SHEET 1 OF 1
 DATE		TITLE SCALE
03.05.13		SPACER BUSHING 2:1
A	94.12.17	NEW ISSUE
В	95.12.06	LENGTH CHANGE
റ	03.05.13	03.05.13 303 SS SPEC ADDED

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES				
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NOTE: Date & initial all entries

DART AEROSPACE LTD Description: Spaces Bushing Inspection Dwg: Rev: C		Work Order: Part Number:	B25	
		Part Number:	2327	
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Date: Owlost 23 Date: O6.03.2			te:	- ·
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